

## CLAMPING DEVICE FOR TOOL HOLDER

**0001]** This application claims priority under 35 U.S.C. §§119 and/or 365 to Patent Application Serial No. 2002-311444 filed in Japan on October 25, 2002; Patent Application No. 2002-329837 filed in Japan on November 13, 2002; and Patent Application No. 2003-207909 filed in Japan on August 19, 2003. The entire contents of those applications are incorporated herein by reference.

### BACKGROUND OF THE INVENTION

**0002]** The present invention relates to a clamping device for attaching a tool holder to various kinds of machine tools including a lathe, a numerical controlled lathe and an automatic copying lathe.

**0003]** A conventional tool assembly 101 comprising a support body 102 and a plurality of tool holders 111 is depicted in Fig. 8. A clamping device for each tool holder 111 shown in Fig. 8 is provided with a wedge-type holder clamping tool 112 having a plurality of fastening bolts 114 and one jack-up bolt 113. A plurality of fastening bolts of the wedge-type holder clamping tool are fastened to the support body 102, so that the tool holder can be connected to the support body via interaction between respective wedge surfaces (not shown) of the wedge-type holder clamping tool 112 and the support body, which interaction pushes the clamping tool 112 against the tool holder 111. When the tool holder is to be removed from the clamping device, the jack-up bolt 113 that has been loosened in advance is screwed against the support body after the plural clamping bolts are loosened, so that the wedge surface of the wedge-type holder clamping tool is forcefully moved away from the wedge surface of the support body. Thus, the tool holder can be removed.

**0004]** Various kinds of devices for simplifying attachment/removal of the tool holder are well known. A device for holding a tool holder shank in a machine tool is disclosed in Japanese Unexamined Patent Publication No. 2000-190110. The device releasably holds a holder shank of the tool holder to which a cutting insert is attached and a lock rod is provided on a base member. The attachment/removal structure between the holder shank and the lock rod is complicated and it is difficult to reduce the size of the device.

**0005]** Japanese Unexamined Patent Publication No. 2001-300802 discloses a detachable securing mechanism of a cutting tool used in a comb-type tool rest of a machine tool such as a numerical controlled lathe. The mechanism is provided with a supporting member for supporting an arrangement of plural tools. The supporting member attaches the cutting tool to the comb-type tool rest of the machine tool by fastening a plurality of mounting bolts.

**0006]** However, in the above conventional clamping device for a tool holder, it takes a long time to attach/remove the tool holder because it is required that a plurality of clamping bolts are fastened or loosened in attachment/removal of the tool holder.

**0007]** Accordingly, there is a problem in miniaturization and simplification of the device because the structure of the device is complicated. In addition, it is difficult to repeatedly and accurately set the position of a top cutting edge because the placement of the cutting holder at a predetermined position must be visually checked.

**0008]** In view of the above conventional prior art, the object of the present invention is to provide a clamping tool capable of reducing an attachment/removal time when one or plural tool holders, especially small tool holders, are attached to or removed from the machine tool such as the lathe, the numerical controlled lathe and the automatic copying lathe, and capable of improving the accuracy in positioning of the tool holder.

## SUMMARY OF THE INVENTION

**0009]** In a clamping device to which one or plural tool holders are attached, according to the present invention, the entire length of a wedge-type holder clamping tool for fastening the tool holder to the clamping device is shorter than that of a conventional clamping tool, and only one fastening bolt is provided on the wedge-type holder clamping tool. When the one fastening bolt is loosened, the clamping tool is forcefully displaced away from the support body, so that the tool holder can be attached to or removed from the clamping device. Preferably, this is done without completely removing the clamping tool or the fastening bolt.

**0010]** With this structure, in the clamping device for the tool holder according to the present invention, the number of the fastening bolts can be reduced and a jack-up bolt can be dispensed with, and thus a miniaturization and simplification of the wedge-type holder clamping tool can be archived. In addition, the reduction of time required for attaching/removing the tool holder to/from the clamping device can be archived without modifying a tool holder generally and currently used.

**0011]** Furthermore, in the clamping device to which the one or plural tool holders are attached, according to the present invention, the clamping device for the tool holder is provided with a stopper block provided at the rear end of the tool holder remotely of a cutting edge of the tool holder, and a wedge-type stopper clamping tool is provided for securing the stopper block to a predetermined position. Thus, the position of the tool holder can be accurately controlled when the tool holder is attached to the clamping device.

**0012]** Furthermore, the wedge-type holder clamping tool according to the present invention is provided with a mounting bolt so that the tool holder can be attached to the clamping device with stability. The mounting bolt is replaced with an elastic mounting tool or a mounting bolt with an elastic

mounting tool, so that the tool holder can be attached to the clamping device with further stability.

#### BRIEF DESCRIPTION OF THE DRAWINGS

**0013]** The objects and advantages of the invention will become apparent from the following detailed description of preferred embodiments thereof in connection with the accompanying drawings in which like numerals designate like elements.

**0014]** Fig. 1(a-1) shows a side view of a tool assembly according to the present invention, with a tool holder secured in place.

**0015]** Fig. 1(a-2) is an end view of Fig. 1(a-1).

**0016]** Fig. 1(b-1) is a view similar to Fig. 1(a-1) of a second embodiment according to the present invention.

**0017]** Fig. 1(b-2) is an end view of Fig. 1(b-1).

**0018]** Fig. 2(a) is a side view of a fastener bolt extending through a holder clamp and carrying an elastic ring, according to the present invention.

**0019]** Fig. 2(b) is a side view of a different fastening bolt having a groove therein for receiving an elastic ring.

**0020]** Fig. 2(c) is a view similar to Fig. 2(b) with the elastic ring mounted in the fastening bolt.

**0021]** Fig. 3 is a side view of a double-threaded fastening bolt according to the present invention.

**0022]** Fig. 4(a-1) is a view similar to Fig. 1(a-1) of a further embodiment according to the present invention.

**0023]** Fig. 4(a-2) is an end view of Fig. 4(a-1).

**0024]** Fig. 4(b-1) is a view similar to Fig. 1(a-1) of still another embodiment according to the present invention.

**0025]** Fig. 4(b-2) is an end view of Fig. 4(b-1).

**0026]** Fig. 4(c-1) is a view similar to Fig. 1(a-1) of still another embodiment according to the present invention.

- 0027]** Fig. 4(c-2) is an end view of Fig. 4(c-1).
- 0028]** Fig. 5(a-1) is a view similar to Fig. 1(a-1) of another embodiment according to the present invention.
- 0029]** Fig. 5(a-2) is a plan view of Fig. 5(a-1).
- 0030]** Fig. 5(a-3) is an end view of Fig. 5(a-1).
- 0031]** Fig. 5(b-1) is a view similar to Fig. 1(a-1) of still another embodiment according to the present invention.
- 0032]** Fig. 5(b-2) is an end view of Fig. 5(b-1).
- 0033]** Fig. 5(b-3) is a sectional view through Fig. 5(b-1).
- 0034]** Fig. 5(b-4) is an end view of Fig. 5(b-3).
- 0035]** Fig. 6(a-1) is a view similar to Fig. 1(a-1) of still another embodiment according to the present invention.
- 0036]** Fig. 6(a-2) is an end view of Fig. 6(a-1).
- 0037]** Fig. 6(b-1) is a view similar to Fig. 1(a-1) of still another embodiment according to the present invention.
- 0038]** Fig. 6(b-2) is an end view of Fig. 6(b-1).
- 0039]** Fig. 6(c-1) is a view similar to Fig. 1(a-1) of still another embodiment according to the present invention.
- 0040]** Fig. 6(c-2) is an end view of Fig. 6(c-1).
- 0041]** Fig. 7(a) is a side view of an alternative form of tool holder according to the present invention.
- 0042]** Fig. 7(b) is a plan view of Fig. 7(a).
- 0043]** Fig. 7(c) is an end view of Fig. 7(b).
- 0044]** Fig. 8 is a view of a prior art tool assembly in which a plurality of tool holders are clamped.
- 0045]** Fig. 9(a) is an end view of a spring plunger screw according to the present invention.
- 0046]** Fig. 9(b) is a sectional view through the spring plunger screw of Fig. 9(a).

**0047]** Fig. 9(c) is an opposite end view of the spring plunger screw of Fig. 9(a).

**0048]** Fig. 10 is a schematic perspective view of a tool assembly according to another embodiment of the present invention wherein a fastening screw is secured by a spring nut.

**0049]** Fig. 11 is a perspective view through a tool holder clamp according to another embodiment of the invention, wherein the fastening screw is secured by a sleeve nut.

**0050]** Fig. 12 is a view similar to Fig. 10, except that the tool assembly is shown from an opposite side, and a biasing spring is disposed therein.

**0051]** Fig. 13 is a view similar to Fig. 12 employing a different type of spring.

**0052]** Fig. 14 is a perspective view of a tool assembly according to a further embodiment of the present invention.

**0053]** Fig. 15 is a perspective view of a tool holder clamp according to yet another embodiment of the present invention.

**0054]** Fig. 16 is a view similar to Fig. 15 of yet another embodiment according to the present invention.

#### DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

**0055]** Depicted in Fig. 1(a-1) is a tool assembly comprising a support body 1A, a tool holder 5 mounted in a groove 1B of the support body, and a clamping device for clamping the tool holder. The tool holder carries a replaceable cutting insert 5-1. In practice, there would be numerous tool holders with respective clamping devices, but only one tool holder is depicted herein. The clamping device includes a stopper block 2 disposed behind the tool holder for positioning the tool holder along an axis A, a wedge-type stopper clamping tool (stopper clamp) 3 for clamping the stopper block in place, a first fastener 6 for securing the clamping tool 3 to the support body 1A, a wedge-type holder clamping tool (holder clamp) 4 for

clamping the tool holder in place, and a second fastener 7 for securing the clamping tool 4 to the support body 1A. The fastener 6 extends through a through-hole 8' formed in the stopper clamp 3, and is secured in the support body 1A by a thread connection. The fastener 7 is similarly attached. Thus, each fastener 6, 7 has a threaded shank that can be directly threaded to the support body, or indirectly thereto as explained in connection with Figs. 10-16.

**0056]** With the above structure, the fastening bolts 6, 7 are rotated in a fastening direction so that the wedge-type stopper clamping tool 3 and the wedge-type holder clamping tool 4 are fastened to the support body 1A, respectively, and are rotated in a loosening direction so that the wedge-type stopper clamping tool 3 and the wedge-type holder clamping tool 4 are moved away from the support body 1A, and thus the tool holder can be detachably attached to the support body.

**0057]** In the support body 1A (to which, for example, one tool holder is attached in the following embodiments) that is shown in Figs. 1(a-1) and 1(a-2), wedge surfaces 12a, 12b of the tool 4 and the support body 1A engage one another to force the tool 4 downwardly against the tool holder 5. Thus, a side face 13 of the wedge-type holder clamping tool 4 and a side face 14 of the tool holder 5 are clamped to each other by forces directed at right angles to the axis A and to a groove bottom (abutment surface) 15 of the support body 1A. In the support body 1A shown in Figs. 1(b-1) and 1(b-2), the side face 13 of the wedge-type holder clamping tool 4 is clamped, at an angle 16, to the side face 14 of the tool holder 5. To this end, the side face 13 of the tool holder must be oriented at an angle 16 shown in Fig. 1(b-2).

**0058]** Figs. 2(a), 2(b) and 2(c) show the clamping tool fastening bolt 7. In these drawings, only the clamping tool fastening bolt 7 is shown. The stopper fastening bolt 6 can be formed into the same shape as that of clamping tool fastening bolt 7. In Fig. 2(a), the clamping tool fastening bolt 7 is attached to the wedge-type holder clamping tool 4. The fastening bolt is

provided with, for example, an elastic element in the form of a ring 17 such as a lock washer or a spring washer. The elastic ring pushes the wedge-type holder clamping tool 4 (or the stopper clamping tool 3 in the case of the fastening bolt 6) in a direction D away from the clamping device upon loosening the fastening bolt when the wedge-type stopper clamping tool 3 or the wedge-type holder clamping tool 4 is to be removed from the clamping device. Therefore, the wedge-type stopper clamping tool 3 or the wedge-type holder clamping tool 4 can be attached to or removed from the clamping device by the use of only one fastening bolt provided with the elastic ring. In order to attach the elastic ring to the fastening bolt, a slit 10 can be provided in the fastening bolt as shown in Fig. 2(b) and the elastic ring is attached to the slit as shown in Fig. 2(c).

**0059]** Furthermore, as shown in Fig. 3, in lieu of using an elastic ring 17, there can be used a fastening bolt 7' with left and right-hand screw threads, i.e., a left-hand thread 7'-1 and right-hand thread 7'-2. When fastening bolts with the left and right-hand screws are used, the bolt through holes 8', 9' in the wedge-type stopper clamping tool 3 and the wedge-type holder clamping tool 4 are replaced with threaded holes having the same pitch as that of the corresponding thread of the corresponding thread of the fastening bolts. For example, the left-hand thread is used for the threaded holes of the wedge-type holder clamping tools 3, 4 because the right-hand thread is used for the threaded holes of a conventional clamping device 1 (for example, a tool rest including an automatic copying lathe). Accordingly, for example, when the tool holder 5 is attached, the fastening bolt 7' with the left and right-hand screws is rotated in an attaching direction, so that the wedge-type holder clamping tool 4 is moved in a direction to clamp the tool holder 5, so as to clamp the tool holder 5 to the support body 1A. On the other hand, the fastening bolt 7' with the left and right-hand screws is rotated in a removing direction, so that the wedge-type holder clamping tool 4 is positively moved away from the tool holder 5 so as to remove the tool holder 5 from the



support body 1A. Similar to the above, when the stopper block 2 is secured by the wedge-type stopper clamping tool 3, the block can be attached or removed by use of fastening bolt 6 with the left and right-hand screws. Thus, the wedge-type stopper clamping tool 3 or the wedge-type holder clamping tool 4 can be attached to or removed from the clamping device by use of only the fastening bolt with the left and right-hand screws. It will be appreciated that the device can be made smaller because the fastening bolt has no portion whose diameter is larger than the diameter of the threaded portions. Namely the clamping device can be applied to a tool holder having a small shaft.

**0060]** The wedge-type holder clamping tool for attaching the tool holder to the clamping device with stability will be described below. In order to attach the tool holder to the clamping device with further stability, as shown in Figs. 4(a-1) to 4(c-2), the wedge-type holder clamping tool 4 is provided with pressing bolts 18-1, 18-2, 18-3 for pressing against the side face 14, a top face or a corner 19 of the tool holder 5. Figs. 4(a-1) to 4(b-2) show the pressing bolt for pressing against the side face 14. Fig. 4(c-1) and 4(c-2) shows the pressing bolt for pressing against the corner 19. As described above, the wedge-type holder clamping tool is provided with the pressing bolt so that the tool holder can be appropriately attached to the side face and the bottom face of the groove of the clamping device with stability.

**0061]** In order to further accurately position the tool holder 5 in the axial direction thereof, according to the present invention, the stopper block 2 can be provided with an adjusting bolt 20 or a positioning bar 23 as adjusting means, as shown in Figs. 5(a-1) to 5(b-4). As shown in Fig. 5(a-1), the first adjusting bolt 20 extends through the stopper block 2 along the central axis thereof, and has a maximum length that is larger than the maximum length of the stopper block. The end face of the adjusting bolt that is in contact with the rear end of the tool holder has a diameter smaller than that of the adjusting bolt. The first adjusting bolt 20 positions the stopper block at a

predetermined position by use of the wedge-type stopper clamping tool 3. The adjusting bolt 20 provided in the stopper block 2 positions the tool holder at a predetermined position. As shown in Fig. 5(b-3), the second positioning bar 23 is inserted into a hole that extends through the stopper block 2 along the central axis thereof. The positioning bar 23 is secured and positioned by a securing bolt 21 and a positioning screw 22 that are engaged in threaded holes provided in one face of the stopper block. The second positioning bar 23 positions the stopper block at a predetermined position by use of the wedge-type stopper clamping tool 3. As shown in Fig. 5(b-3), the chamfered end of the positioning bar 23 on the side of the bar that faces the tool holder is pressed against the tool holder to position the tool holder by use of the positioning screw 22 provided in the stopper block 2. After that, the positioning bar 23 is secured by the securing bolt 21. This enables the tool holder to be extremely accurately positioned at a predetermined position.

**0062]** Another means for positioning the tool holder 5 in the axial direction thereof will be described below. As shown in Fig. 6(a-1) to 6(c-2), V-shaped cuts or recesses 24 are provided at a longitudinal corner of the tool holder 5. In addition, the wedge-type holder clamping tool is provided with at least one pressing bolt 18-1 (in Fig. 6(a-1)(a-2)), pressing bolt 18-2 (in Figs. 6(b-1)(b-2)), and pressing bolt 18-3 (in Fig. 6(c-1)(c-2)). At least one pressing bolt 18-1, 18-2, 18-3 is pressed against an inclined surface (near the stopper block) of the V-shaped cut 24, so that the tool holder 5 can be pressed against the stopper block 2 at a predetermined pressure. The pressing bolt 18-1 is engaged toward the side face of the clamping device; the pressing bolt 18-2 is engaged toward the bottom face of the groove of the clamping device; and the pressing bolt 18-3 is engaged at a predetermined angle with respect to the side face and the bottom face of the groove of the clamping device. By means of any of the pressing bolts, the tool holder can be pressed against the side face and the bottom face of the groove of the

clamping device. The top end of the pressing bolt 18-1, 18-2, 18-3 is shaped into a hemisphere or a cone corresponding to the V-shaped cut. However, if no cut is provided, the top end can be flat.

**0063]** The wedge-type holder clamping tool that attaches the tool holder to the clamping device with further stability will be described below. In order to attach the tool holder to the clamping device with further stability, the wedge-type holder clamping tool 4 is provided with the elastic pressing tool or the pressing bolt with the elastic pressing tool in place of the pressing bolts shown in Fig. 6(a-1) to 6(c-2). Also, the elastic pressing tool or the pressing bolt with the elastic pressing tool is pressed against the side face 14, the top face or the corner 19 of the tool holder 5. As described above, the wedge-type holder clamping tool is provided with the elastic pressing tool or the pressing bolt with the elastic pressing tool, so that the tool holder can be appropriately attached to the side face and the bottom face of the groove of the clamping device with stability. A spring coil, an elastic rubber, a plate spring, a spring washer, a coned disc spring, a spring plunger screw or the like is used as the elastic pressing tool and in the pressing bolt with the elastic pressing tool. As an example of the elastic pressing tool and the pressing bolt with the elastic pressing tool, a spring plunger screw is shown in Fig. 9(a-c). The spring plunger screw 26 is provided with: (i) a screw portion 26-1 that presses the tool holder against the abutment surfaces of the groove 1B, (ii) a top end (having a round or flat end) 26-2 that abuts with the tool holder, (iii) a plug screw 26-3 that secures a spring, and (iv) a spring 26-4 that presses the tool holder via the top end thereof.

**0064]** Means for positioning the tool holder 5 in the axial direction thereof by using the elastic pressing tool or the pressing bolt with the elastic pressing tool in place of the above pressing bolts will be described below. In such means, the V-shaped cuts 24 are provided at a longitudinal corner of the tool holder 5 shown in Fig. 6(a-1) to 6(c-2), and the wedge-type holder clamping tool is provided with at least one pressing bolt with the elastic

pressing tool (for example, the spring plunger screw in Fig. 9a-c) in place of the pressing bolts shown in Fig. 6(a-1) to 6(c-2). In such means, at least one pressing bolt with the elastic pressing tool is pressed against such an inclined surface (near the stopper block) of the V-shaped cut 24, so that the tool holder 5 can be pressed against the stopper block 2 at a predetermined pressure. The pressing bolt with the elastic pressing tool used in place of the pressing bolt shown in Fig. 6(a-1)(a-2) is engaged toward the side face of the clamping device; the pressing bolt with the elastic pressing tool used in place of the pressing bolt shown in Fig. 6(b-1)(b-2) is engaged toward the bottom face of the groove of the clamping device; and the pressing bolt with the elastic pressing tool used in place of the pressing bolt shown in Fig. 6(c-1)(c-2) is engaged at a predetermined angle with respect to the side face and the bottom face of the groove of the clamping device. By means of any of the pressing bolts with the elastic pressing tool (e.g., a spring plunger screw, a spring coil, an elastic rubber, a plate spring, a spring washer, a coned disc spring or the like), the tool holder can be pressed against the side face and the bottom face of the groove of the clamping device. The top end of the elastic pressing tool that abuts with the V-shaped cut 24 is shaped into a hemisphere or a cone corresponding to the V-shaped cut. However, if no cut is provided, the top end can be flat.

**0065]** Furthermore, in the present invention, the attaching efficiency and the positioning of the tool holder 5 can be further improved by modifying a part of the tool holder 5. As shown in Fig. 7(a-c), in order to improve the attaching efficiency of the tool holder 5, a chamfer 25 (e.g., a back taper, a truncated cone shape, spherical shape or plural combinations of the back taper, a truncated cone shape and a spherical shape) is provided on the rear end of the tool holder, so that the tool holder can be easily attached to the support body 1A.

**0066]** Furthermore, in the clamping device according to the present invention, a conventional long tool holder can be attached in place of the

stopper block 2, by using both the wedge-type stopper clamping tool 3 and the wedge-type holder clamping tool 4.

**0067]** The holder clamping tool 4 can be held in place as shown in Figs. 10 and 11. As shown in Fig. 10, in the clamping device of the tool holder according to the present invention, the fastening bolt 7 of the wedge-type holder clamping tool 4 is attached to a spring nut 121 to define a thread connection. The spring nut 121 prevents the clamping tool fastening bolt 7 from being detached from the wedge-type holder clamping tool 4, and the wedge-type holder clamping tool 4 is held between the nut 121 and a head of the bolt 7.

**0068]** As shown in Fig. 11, in the clamping device of the tool holder according to the present invention, the fastening bolt 7 of the wedge-type holder clamping tool 4 is fastened to a threaded sleeve-type nut 122 to define a thread connection. Rotation of the nut 122 is facilitated by a knurled ring 123.

**0069]** In each of Figs. 10 and 11, the holder clamping tool 4 has a slot 9" elongated in a direction transversely of the axis A and through which the bolt 7 passes. As a result, by loosening the bolt 7 and slightly displacing the holder clamping tool 4 out of the groove 1B, the clamping tool 4 can be raised away from the tool holder in order to allow removal (or insertion) of the tool holder even while the fastening bolt 7 remains secured in the support body 1A. Thus, with any structure having the feature described with reference to Figs. 10 and 11, the tool holder 4 can be temporarily fastened without completely detaching the clamping tool fastening bolt 7 or the holder clamp 4.

**0070]** Other types of wedge-type holder clamping tools 4 which can temporarily fasten the tool holder 5 without fully detaching the clamping tool 4 or the fastening bolt 7 will be described below with reference to Figs. 12 to 16, wherein a spring is provided which presses the holder clamp 4 against the tool holder 5 to hold the latter in place.

**0071]** As shown in Fig. 12, in the clamping device of the tool holder according to the present invention, the fastening bolt 7 is fastened to the spring nut 121. An upwardly extending spring mounting slit 127 is provided in the holder clamp 4 to one side of the elongated through hole 9" of the wedge-type holder clamping tool 4. A biasing spring 126 extends into the slit so that a spring end 126-1 exerts an elastic biasing force in a direction to increase a distance between the clamping device and a wedge-type side face 12a of the wedge-type holder clamping tool 4, so that the holder clamping tool 4 presses against the holder 5. Thus, the tool holder 5 remains temporarily fastened to the support body 1A even while the clamping bolt fastening tool 7 is loosened but still secured to the support body 1A. In that state, the tool holder 5 can be inserted or removed.

**0072]** As shown in Fig. 13, the biasing spring 128 has an end 128-1 which exerts the elastic biasing force described above.

**0073]** As shown in Fig. 14, the fastening bolt 7 is fastened to the sleeve nut 122. A leaf spring 124 is provided in the wedge-type holder clamping tool 4 between the sleeve nut 122 and a wedge-type side face 12a of the wedge-type holder clamping tool to temporarily fasten the tool holder 5 to the clamping device. Accordingly, the leaf spring 124 exerts an elastic force in a direction to increase a distance between the wedge-type side face 12a and the sleeve nut 122. Thus, the holder clamping tool 4 presses against the tool holder 5, wherein the tool holder 5 remains temporarily fastened to the clamping device, even when the clamping bolt fastening tool 7 is loosened.

**0074]** As shown in Fig. 15, a coil spring 125 having a fixed end is provided in place of the leaf spring 124. Accordingly, the coil spring 125 having a fixed end exerts an elastic force in a direction to increase a distance between the wedge-type side face 12a and the sleeve nut 122, so that the tool holder 5 is temporarily fastened to the clamping device, when the clamping bolt fastening tool 7 is loosened.

**0075]** As shown in Fig. 16, the wedge-type holder clamping tool 4 is provided with the sleeve nut 122. A laterally biasing spring mounting slit 131 is provided in one of opposite side surface portions of the bolt through hole 9" of the wedge-type holder clamping tool 4 in the minor axis direction thereof. A laterally biasing spring 129 is mounted in the laterally biasing spring mounting slit. One end of the laterally biasing spring 129 is inserted into a hole 132 of the laterally biasing spring mounting slit, and the other end of the laterally biasing spring 129 is disposed between the clamping device fastening bolt 7 and the wedge-type side face 12a. With this structure, the laterally biasing spring 129 exerts an elastic force in a direction to increase a distance between the wedge-type side face 12a and the sleeve nut 122, so that the tool holder 5 is temporarily fastened to the clamping device 1, when the bolt 7 is loosened.

**0076]** Therefore, with any structure described with reference to Figs. 12 to 16, the tool holder 5 can be temporarily fastened without detaching the clamping device fastening bolt 7 from the wedge-type holder clamping tool 4. The tool holder 5 can also be inserted and detached from the support body 1A with the bolt 7 being loosened. Moreover, the features disclosed in connection with Figs. 10-16 can be employed in conjunction with a part which pushes the clamp in a direction away from the groove 13 upon loosening the bolt 7, such as the elastic ring 17.

Effect of the Invention:

**0077]** In the clamping device for the tool holder according to the present invention, the number of fastening bolts for the tool holder can be reduced; the jack-up screws can be dispensed with; and a miniaturization and the simplification of the wedge-type holder clamping tool can be achieved. Thus, the time required for attachment/removal of the tool holder can be reduced without modifying the tool holder and the clamping device for the tool holder that are currently used.

**0078]** Furthermore, in the clamping device for the tool holder according to the present invention, the tool holder can be disposed at an accurate position, and can be repeatedly disposed at the same accurate position even when replaced. Also, in the clamping device for the tool holder according to the present invention, the tool holder can be temporarily fastened without being detached from the clamping device and without detaching the clamping tool fastening bolt from the wedge-type holder clamping tool when the tool holder is attached to and detached from the clamping device.

**0079]** Although the present invention has been described in connection with preferred embodiments thereof, it will be appreciated by those skilled in the art that additions, deletions, modifications, and substitutions not specifically described may be made without departing from the spirit and scope of the invention as defined in the appended claims.